

# Work Order ID 71006

Tuesday, June 21, 2011 9:00:28 AM



Page 1

Item ID:	D2803-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Bracket Assembly				Stop	
Start Date:	6/20/2011	Start Qty:	2.00			
Required Date:	6/23/2011	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	6-21-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2803	Rev B								

100  
 Small Fab 0.00  
 Small Fab Memo 0.00  
 Small Fab Press D2805-1 and D2809 into arm as per Dwg D2803

*Handwritten:* 6/21/11 (2)

110  
 QC 0.00  
 Quality Control Memo 0.00

*Handwritten:* 8/10/11

*Handwritten:* 72

120  
 Powdercoat 0.00  
 Powder Coating Memo 0.00

*Handwritten:* M116964

*Handwritten:* 2:00  
 START TIME: 32005  
 FINISH TIME: 2:30  
☐ OVEN TEMPERATURE:

*Handwritten:* 2x of M-11/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





**NOTE:** Date & initial all entries



**Work Order ID 71006**




Tuesday, June 21, 2011 9:00:28 AM



Page 2

Item ID: D2803-041      Accept            Setup      Start        
Revision ID:            Cust Item ID:      Stop        
Item Name: Bracket Assembly            Customer:  
Start Date: 6/20/2011      Start Qty: 2.00  
Required Date: 6/23/2011      Req'd Qty: 2.00  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start        
QC:      Date:      SPC (Y/N):      Date:      Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00						2	BL 11-6-23
150  Small Fab Small Fab	Small Fab  Memo Assemble as per Dwg D2803.	0.00  0.00							ES 11/06/23 (2)
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00						(2)	251

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 71006**

Tuesday, June 21, 2011 9:00:28 AM



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Item ID: D2803-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 6/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>148</u>	0.00							
Packaging	Memo	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

ca/6/22

11/6/27

MF

11-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 9:00:34 AM

Page 1  
2

Work Order ID: 71006

Parent Item: D2803-041

Parent Item Name: Bracket Assembly







Start Date: 6/20/2011

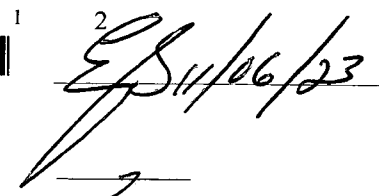
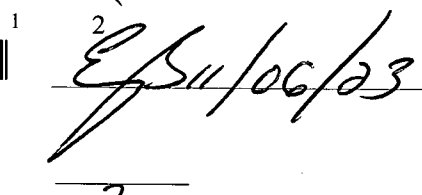
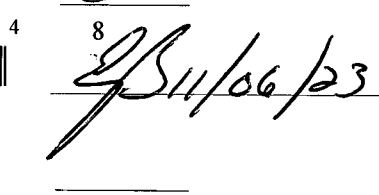
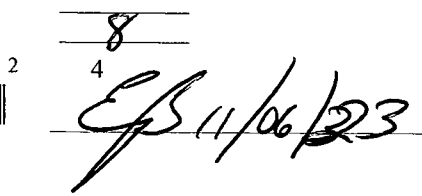
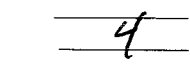
Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1  Bracket		Manufactured	No			100	Each	2.0000	1	2			
<div> <div>Location</div> <div>ST148</div> <div>46610</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2805-1  Stop		Manufactured	No			100	Each	8.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>62247</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
NAS1515H3  Washer		Purchased	No			100	Each	96.0000	4	8			
<div> <div>Location</div> <div>ST277</div> <div>116373</div> <div>117460</div> </div> <div> <div>Loc Qty</div> <div>96</div> <div>6</div> <div>90</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN3C16A  Bolt		Purchased	No			150	Each	29.0000	2	4			
<div> <div>Location</div> <div>ST352</div> <div>115835</div> </div> <div> <div>Loc Qty</div> <div>29</div> <div>29</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, June 21, 2011 9:00:35 AM

Page 2

Work Order ID: 71006

Parent Item: D2803-041

Parent Item Name: Bracket Assembly

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

D2809

Manufactured No

150 Each

22.0000

1



Bushing



2  
EP 11/06/23

Location

Loc Qty

Loc Code

ST

10

70805

10

ST023

12

34035

12

MS21043-3

Purchased

No

150 Each

1,215.000

2



Nut



4  
EP 11/06/23

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1143

112314

143

118077

1000

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING

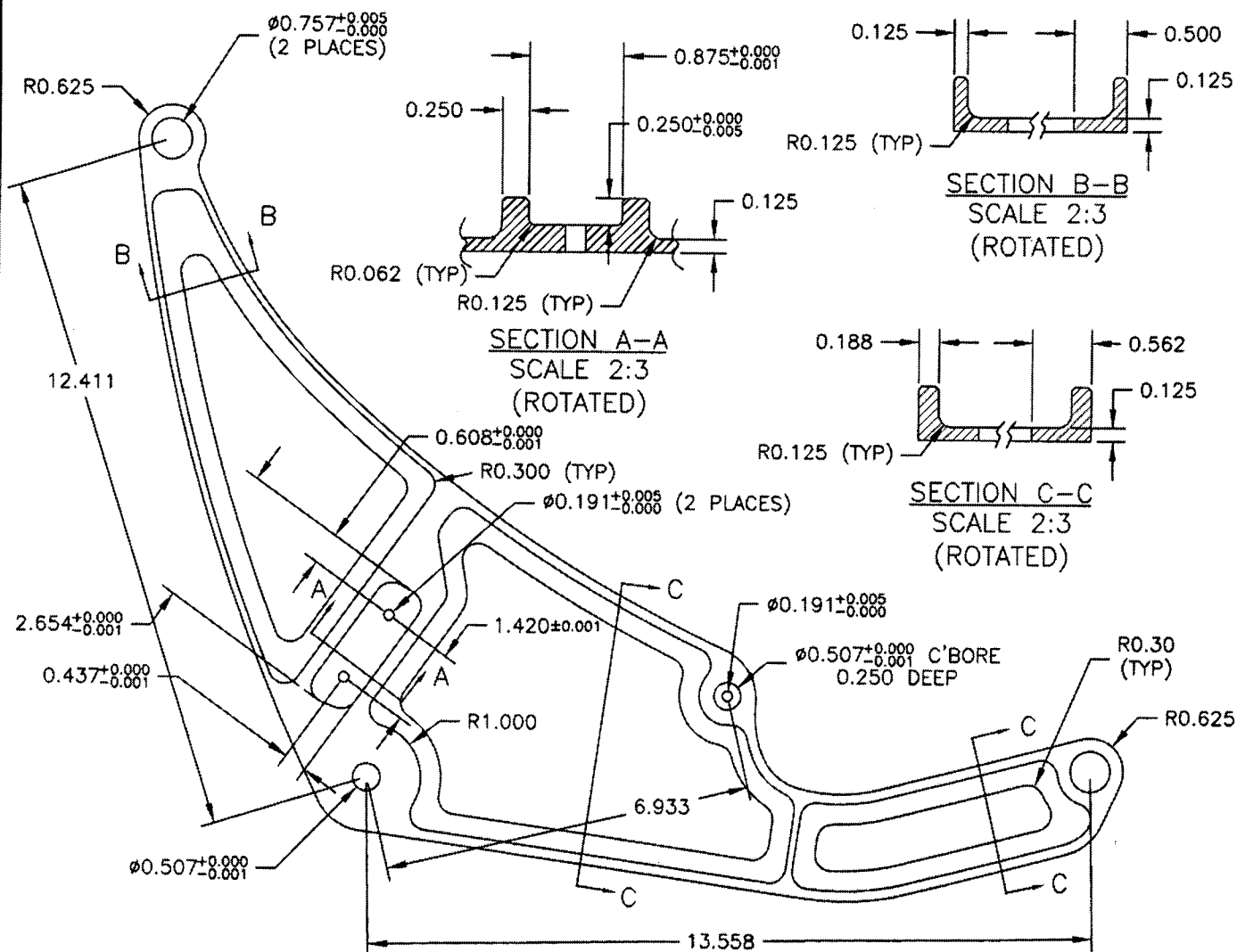


WORK ORDER  
NO. 11004

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11



# **D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

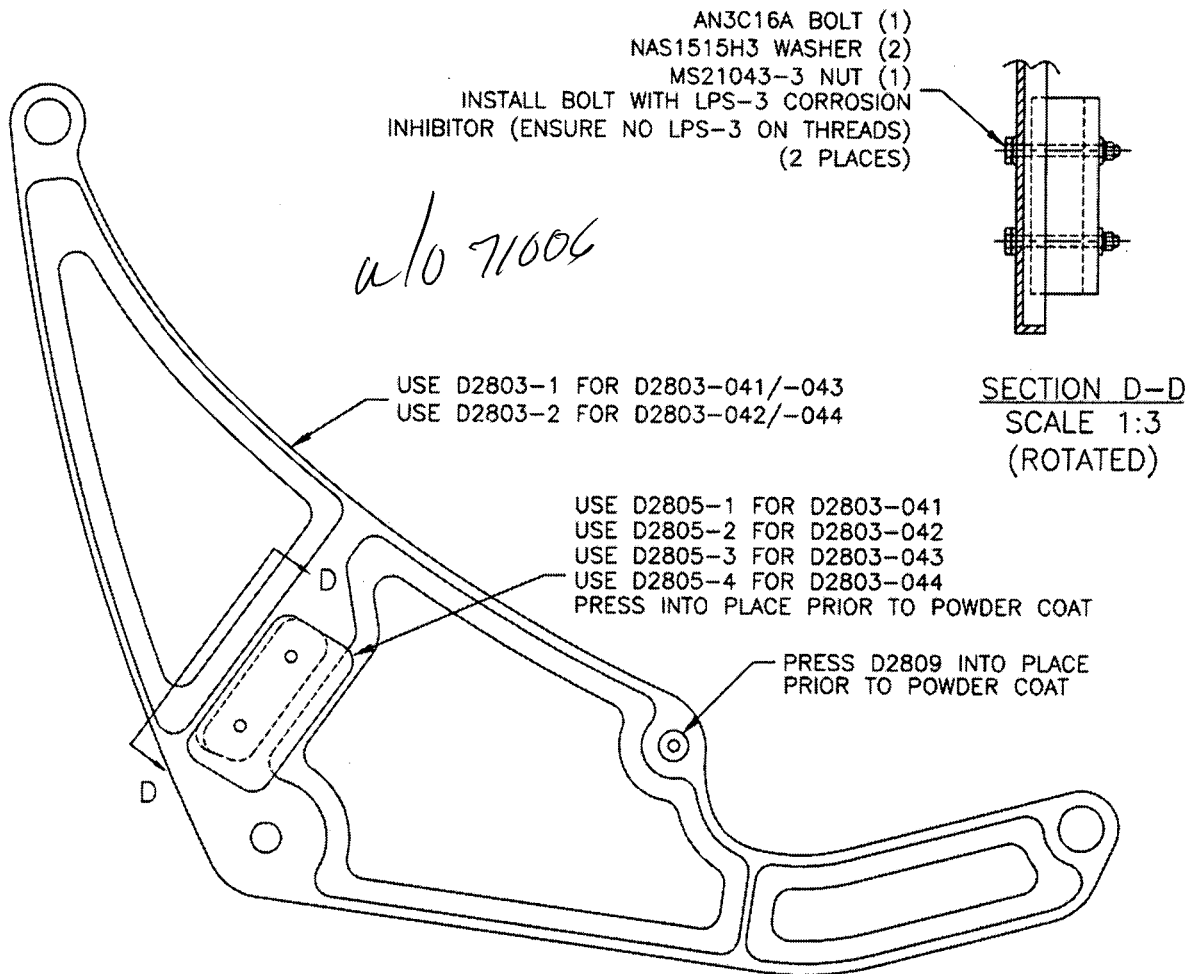
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11

**D2803-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries